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D3201-1
Job Sheet 213248



Part No: D3201-1

Job Qty: ~~8~~ ⁷ pcs

DAS
21
9-89

Part Name: Doubler



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/21/20

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 10/28/20

Type: Stock

Description: SIOP

Note: DWG REV B IPP Rev:A Removed from 9 Digit 06-01-25 JLM IPP Rev:B Now on Waterjet 06-08-14 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	6 pcs		10/27/20	0.17	0.23	Waterjet - Flow		on 20/10/08
120	QC 8	6 pcs		10/27/20	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
							QC 8 - 61		
							QC 8 - 66		
							QC 8 - 73		

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				QC 8 - 82	OCT 0 8 2020
140 Handfinish - 1-1 Chemical-B4B	6 pcs	10/28/20	0.00 0.22	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	DAS 47 9-89 OCT 13 2020
150 QC 7	6 pcs	10/28/20	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
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OCT 13 2020

OCT 15 2020

160 Packaging 3-1 - Stock - B4B

6
pcs

10/28/20

0.00 0.00

QC 7 - 40
QC 7 - 24
QC 7 - 43
QC 7 - 61
QC 7 - 81
QC 7 - 76
QC 7 - 79
QC 7 - 83
QC 7 - 82
QC 7 - 87

Packaging 3 - 1 - B4B
Packaging 3 - 2 - B4B
Packaging 3 - 3 - B4B
Packaging 3 - 4 - B4B
Packaging 3 - 5 - B4B
Packaging 3 - 6 - B4B
Packaging 3 - 7 - B4B
Packaging 3 - 8 - B4B
Packaging 3 - 9 - B4B
Packaging 3 - 10 - B4B
Packaging 3 - 11 - B4B
Packaging 3 - 12 - B4B
Packaging 3 - 13 - B4B
Packaging 3 - 14 - B4B
Packaging 3 - 15 - B4B
Packaging 3 - 16 - B4B
Packaging 3 - 17 - B4B
Packaging 3 - 18 - B4B
Packaging 3 - 19 - B4B
Packaging 3 - 20 - B4B
Packaging 3 - 21 - B4B
Packaging 3 - 22 - B4B
Packaging 3 - 23 - B4B
Packaging 3 - 24 - B4B
Packaging 3 - 25 - B4B
Packaging 3 - 26 - B4B
Packaging 3 - 27 - B4B
Packaging 3 - 28 - B4B
Packaging 3 - 29 - B4B
Packaging 3 - 30 - B4B
Packaging 3 - 31 - B4B
Packaging 3 - 32 - B4B
Packaging 3 - 33 - B4B
Packaging 3 - 34 - B4B
Packaging 3 - 35 - B4B
Packaging 3 - 36 - B4B
Packaging 3 - 37 - B4B

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OCT 15 2020

170 QC 21 - SA

6
pcs

10/28/20

0.00 0.00

QC 21 - SA - 21
QC 21 - SA - 70
QC 21 - SA - 9
QC 21 - SA - 77
QC 21 - SA - 28

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Part Op 100 - 1-Cut as per Dwg D3201

Descriptions: 120 - (QC8- Inspect parts - second check)

140 - (Chemical Conversion Coat per QSI005 4.1)

150 - (QC7-Inspect Chemical Conversion Coat)

160 - (Identify as per dwg & Stock Location:_____)

170 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.040	2024-T3 .040 Sheet	1.6560 sf (.276 ea)	100-Waterjet - Flow - 1	S242857

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.040	2	82	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	0.500inches $\pm$ 0.030	0.530 0.470		
2	Doubler	3.570inches $\pm$ 0.030	3.600 3.540		
3	Doubler	0.120inches $\pm$ 0.030	0.150 0.090		
4	Doubler	8.000inches $\pm$ 0.030	8.030 7.970		
5	Doubler	0.580inches $\pm$ 0.030	0.610 0.550		
6	Doubler	4.890inches $\pm$ 0.030	4.920 4.860		
7	Doubler	0.250inches $\pm$ 0.030	0.280 0.220		
8	Doubler	0.040inches $\pm$ 0.010	0.050 0.030		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S305670



Part: D3201 - 1

Job No: 213248

Serial No/Batch: S305670

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 10/08/20